

Work Order ID 160931

Friday, May 05, 2017 10:35:08 AM

160931

Page 1

Item ID: PB67-43001-213 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Flanged Hook
Start Date: 5/9/2017 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 5/17/2017 Req'd Qty: 14.00 ***14*** Customer:
Reference: SCHEDULED/U
Approvals: Process Plan: DAS 21 9-89 Date: MAY 05 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	1.15							
Jeaspa Bandsaw	Cut blanks: 2.00" x 1.00" x 2.750" long								
110		0.95							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	2.45							
HAAS CNC vertical machine #1	Machine as per Folio FA531 and Dwg B67-43001 Identify as B67-43001-213 Dwg Rev <u>C</u> Folio Rev <u>DA</u>								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.14							
Quality Control									

P.T.O.

DQA:

Date: 17-05-07



QA Closed:

Date: MAY 15 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 160931		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. PBC67-43001-213		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. 17-6408		Scrap ☒		Machining ☒		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
NCR No. 17-6409		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
Suspected Unapproved ☐				Large Fab ☐		Composite ☐		Supplier ☐			
Date: 17-05-07		Step #: 110		QTY Effective: 2				MRB (QSI042) Approval DAS 9 9-89 17-05-03			
Description Work Order Deviation				Disposition				Completed By K/ 17-05-07 S.S.			
① - Used wrong program (1st piece) ② - Tightened part too much in the vise and marked the part (2nd piece)				Scrap & Replace B136882. 1+2				Lead hand / Supervisor Approval Verification DAS 20 17-05-07 9-89			
								QC / QA Coordinator Approval DAS 9 9-89 17-05-03			
Root Cause				FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☒	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☒	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐										
Misidentified ☐	Past Due ☐	OTHER :									

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Page 2

Item ID: PB67-43001-213

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Flanged Hook

Start Date: 5/9/2017 Start Qty: 14.00

14

Cust Item ID:

Required Date: 5/17/2017 Req'd Qty: 14.00

14

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.28				14	0		DAS 45 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>W2003</u> Memo	0.00 0.14				14			MAY 09 2017 DAS 21 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.40							17/5/11 DAS 21 9-89

DAS
21
9-89

MAY 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Page 1

Work Order ID: 160931

160931

Parent Item: PB67-43001-213

PB67-43001-213

Parent Item Name: Flanged Hook

Start Date: 5/9/2017

Required Date: 5/17/2017

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP A05.06.08New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	5.9160	0.2396	3.530947			

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

Location

Loc Qty

Loc Code

MAT

5.916

→ M136882

5.916

2.604.

0.467

Kt 17-05-07

DQA: _____ Date: _____

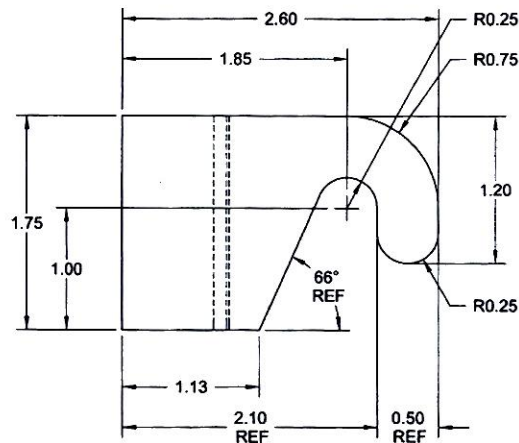
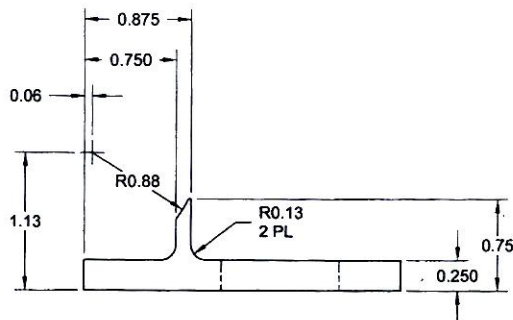


WORK ORDER NON-CONFORMANCE / UPDATE

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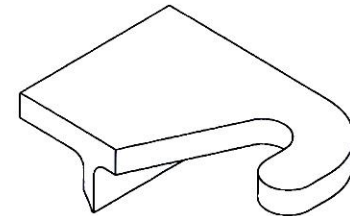
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							



B67-43001-213 FLANGED HOOK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs



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WITHOUT NOTICE
WORK ORDER
NO. 160931 MJS
170505

RELEASED
2009-09-24
mjd

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 17 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.24
REV.		DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-213	SHEET 1 OF 1	
APPROVED	AS	TITLE	SCALE	
DE APPR.	N/A	FLANGED HOOK	NTS	
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